Dart Aerospace Ltd. Tuesday, 04/11/2008 2:03:22 PM User Melanie Fauteux **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : SQUARE TUBE Job Number : 43199 - 2 Estimate Number : 13420 P.O. Number Part Number : PB6743001207 This Issue : 04/11/2008 S.O. No. : **Drawing Number** : B6743001 P.5/ P.16 Prsht Rev. : NC : N/A Project Number First Issue : 11 Type : LARGE FAB ASSY **Drawing Revision** : B1 Previous Run : 42603 Material Written By **Due Date** : 11/11/2008 Checked & Approved By Comment : Est Rev:A 08-06-26 new issue DD verified by:ec **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 6061T6 SQ TUBE 1.00 x 1.00 X .120w Comment: Qty.: 1.9469 f(s)/Unit Total: 9.7346 f(s) 6061T6 SQ TUBE 1.00X.120 batch: 2.0 SMALL & MEDIUM FAB RESOURCE Comment: SMALL & MEDIUM FAB RESOURCE 1 1- cut to length as per dwg 2- make a 0.090" chamfer on both ends of tube 3- deburr INSPECT WORK TO CURRENT STEE Comment: INSPECT WORK TO CURRENT STEP MILLING CONV 4.0 CONVENTIONAL MILLING MACHINE Comment: CONVENTIONAL MILLING MACHINE 1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

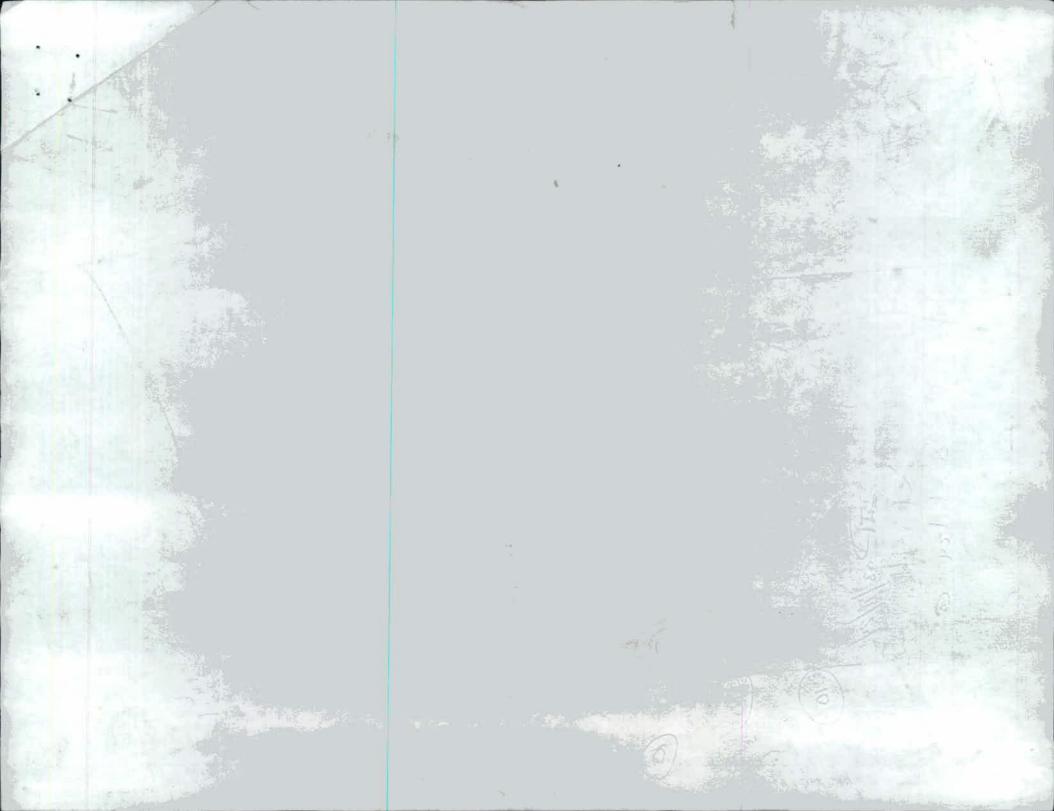
QC5

INSPECT WORK TO CURRENT STEF

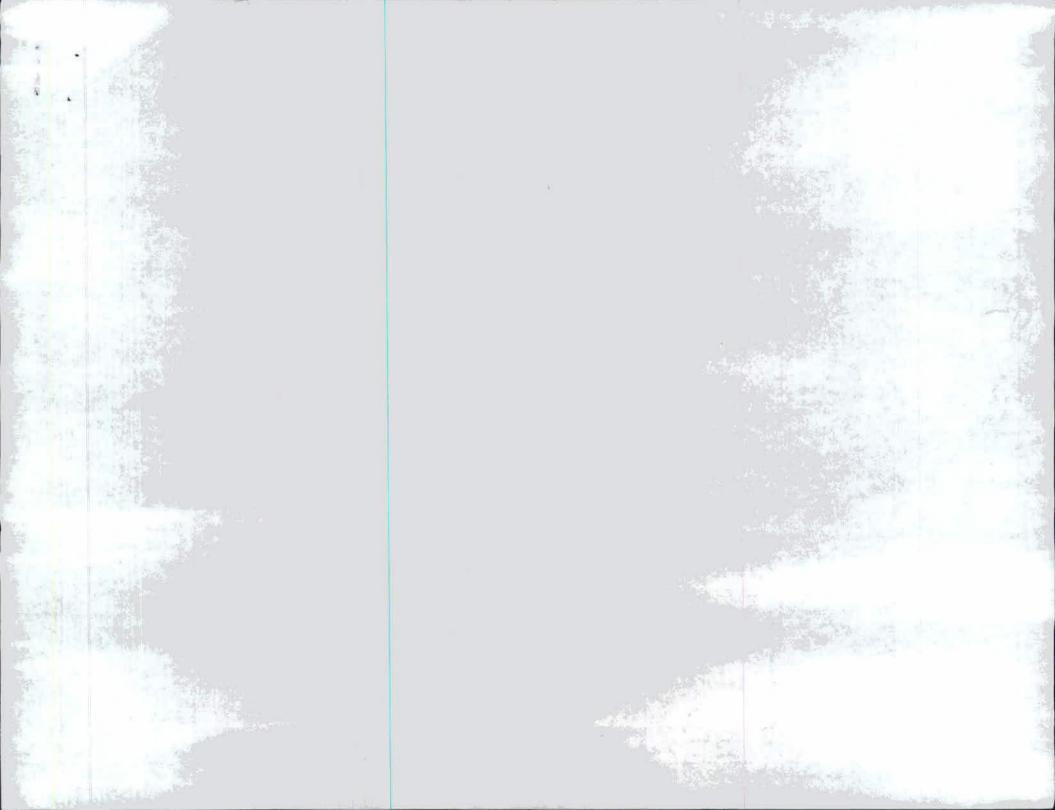
Comment: INSPECT WORK TO CURRENT STEP

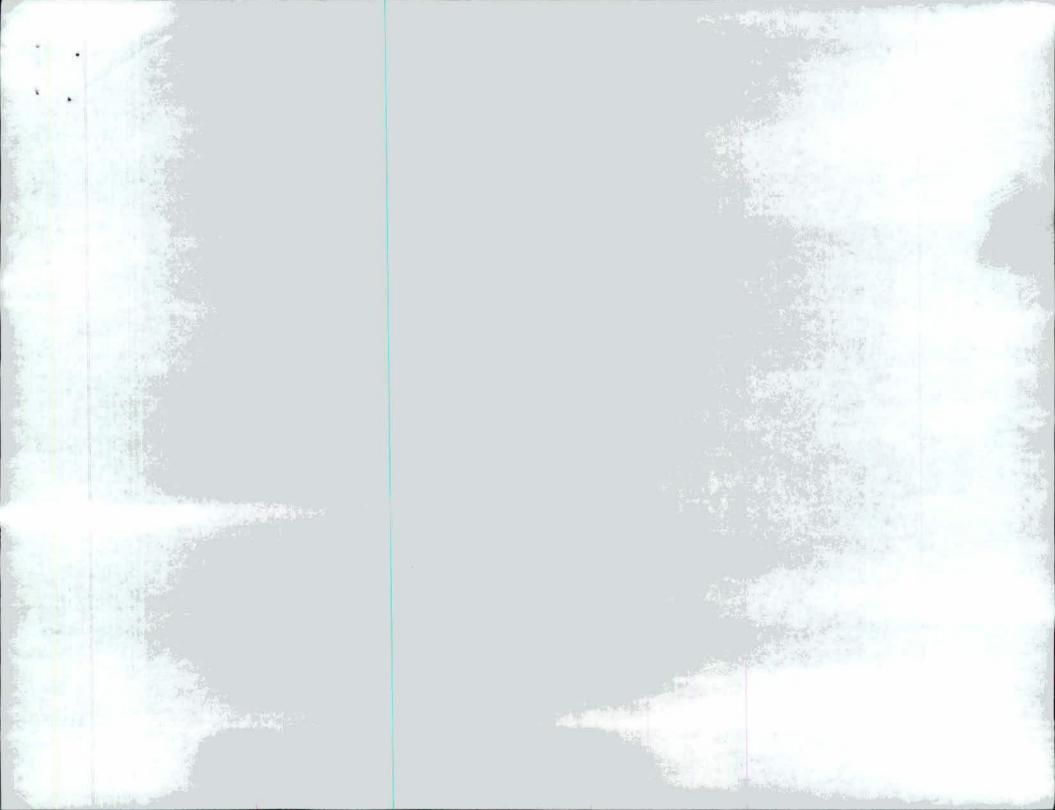


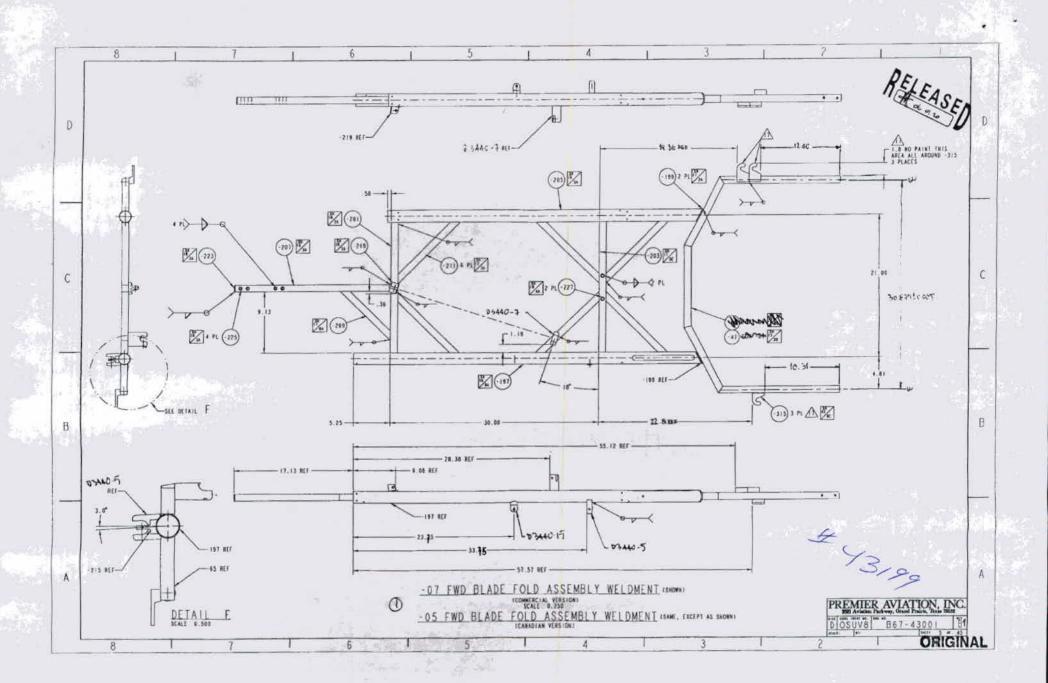
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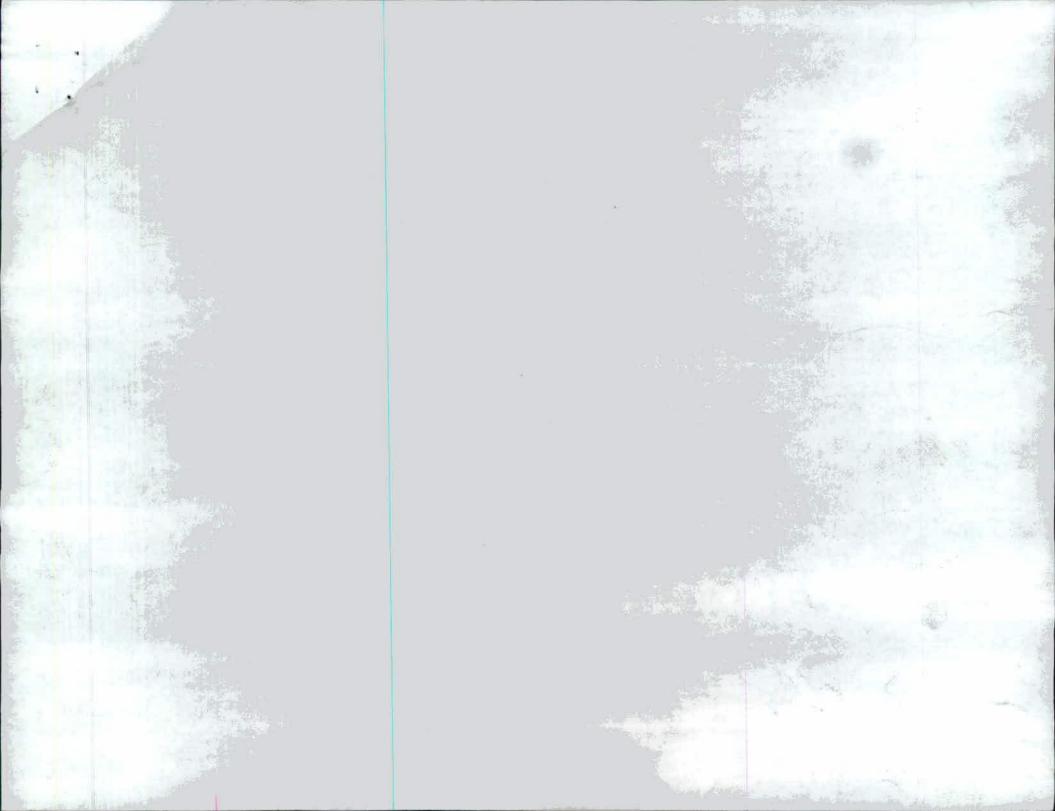


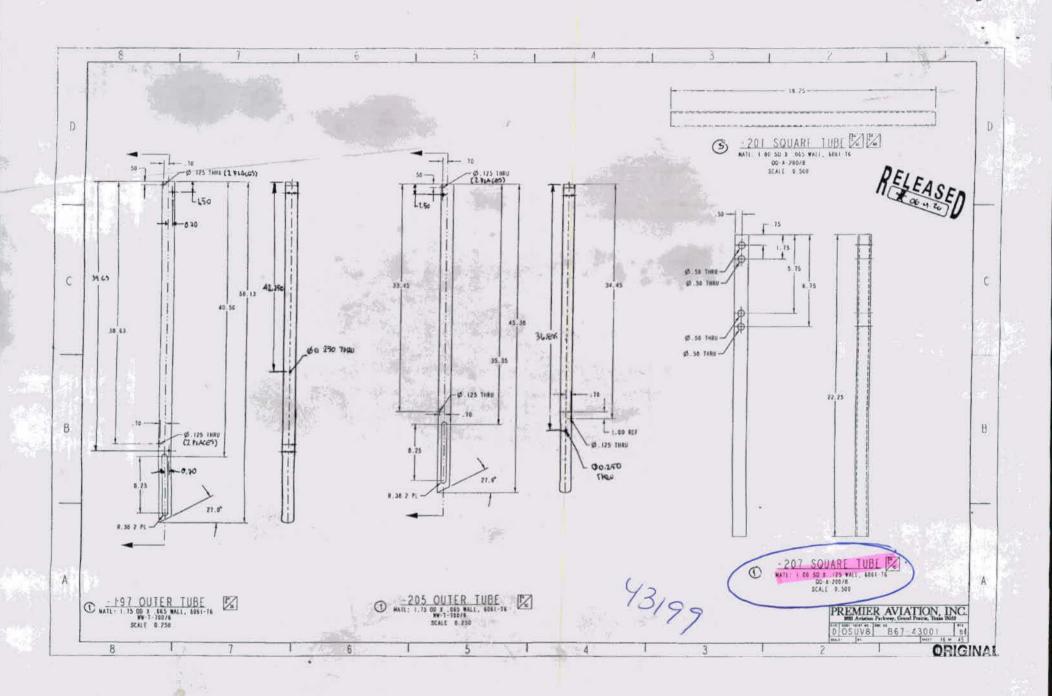
Date: Tuesday, 04/11/2008 2:03:22 PM User: Melanie Fauteux **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SQUARE TUBE Job Number: 43199 Part Number: PB6743001207 Job Number: Seq. #: Machine Or Operation: Description: 6.0 PB6743001225 Bushina Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s) Bushing batch: PB6743001223 7.0 Square Cap Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) 8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1- Weld assembly as per dwg 9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush 2- deburr 10.0 QC10 VISUAL INSPECTION OF GROUND WELDS Comment: VISUAL SPECTION OF GROUND WELDS 11.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 12.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 13.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE MUF 08-12-1













DART AEROSPACE LTD	Work Order:	43199	
1 1	247	10v. 81	
Description: Souare Tube	4	Part Number:	PB6743001207
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Inspection Dwg: , Rev: R1			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
0.50	±0.030	0.50				
0.75	±0.030	0.75	/			
1.75	± 0,030	1.75	/			3
5.75	± 0,030	5.75	/			7 4 5 .
6.75	± 0,030	6.75	/	b.	100	
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Measu	red by:	M.S.	Audited by:	8.	Prototype Approval	. 1	
	Date:	08/11/24	Date:	05/4/24	Date	:	14
Rev	Date	Change			Revise	d by	Approved
A		New Issue			KJ/JLM		1.0



